

Work Order ID 57077

Saturday, March 20, 2010 9:50:59 AM

Page 1

Item ID: D3915-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Light Lid ass'y, Long lid

Start Date: 3/22/2010 Start Qty: 1.00

Required Date: 3/31/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

PRELIMINARY ISSUE

Reference:

Approvals:

Process Plan: MF

Date: 10-3-20

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3915

PA1

100



Large Fab

Large Fab

Weld per dwg A/R Aluminum rod Batch: 0.00

Large Fab

Memo

1- assemble ribs , weld as per dwg D3915

****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE
A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID
FRAME****

2- weld hinge, label plate and Mounting plates as per dwg D3915

0.00

0.00

0.00

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

Cpl 10-03-29

T70

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: / Date: 11-01-28

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11-01-24		Scrap - Nao of Rev C	U 11-01-24	Scrap	Ppl 11-01-24	S 11-01-28 11-01-28	U 11-01-24	/ 11-01-28

NOTE: Date & initial all entries

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							
130 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish Hand Finishing	Memo ***ENSURE TO RINSE CAREFULLY ACID AND ALODINE***	0.00							
140 	Weld per dwg A/R Aluminum rod Batch: _____	0.00							
Large Fab Large Fab	Memo 1- weld (4) corners	0.00							

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

1- touch up corner with alodine only
2- Plug holes prior to

1ST COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

***** 2nd coat if necessary*****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Saturday, March 20, 2010 9:50:58 AM

Work Order ID: 57077



Parent Item: D3915-041



Parent Item Name: Light Lid ass'y, Long lid

Start Date: 3/22/2010

Required Date: 3/31/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2957		Manufactured	No			100	Each	6.0000	4.0000			
-------	--	--------------	----	--	--	-----	------	--------	--------	--	--	--



Mounting Plate

Pl 10.03.29

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

29869

36399

56660

~~B57088~~ → 3

6

2

1

3

1

D3915-1 -

Manufactured No



Rib

D4016-5

Manufactured No



Hinge Half, Light Lid

100	Each	0.0000	2.0000
-----	------	--------	--------



B57089 → 2 Pl 10.03.29

100	Each	6.0000	3.0000
-----	------	--------	--------



B56951 → 3 Pl 10.03.29

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ENG

56075

6

6

D4019-3 -

Manufactured No



Rib

D4035-045 -

Manufactured No



Lid Rib Assembly, Fwd (Light)

100	Each	0.0000	3.0000
-----	------	--------	--------



B57090 → 3 Pl 10.03.29

100	Each	0.0000	1.0000
-----	------	--------	--------



B56972 → ① Pl 10.03.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Parent Item: D3915-041

Parent Item Name: Light Lid ass'y, Long lid






Start Date: 3/22/2010

Required Date: 3/31/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4035-047 		Manufactured	No			100	Each	0.0000	1.0000			
Lid Rib Assembly, Aft (Light)												
D4056-1 		Manufactured	No			100	Each	2.0000	1.0000			
Label Plate												
				<u>Warehouse</u>	<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>				
				Main Warehouse								
				WA			2					
				56661			2					
D2728-1 		Manufactured	No			180	Each	0.0000	1.0000			
Dart Logo label												
D4029-041 		Manufactured	No			180	Each	0.0000	1.0000			
Webbing (Long Basket)												
D4086-220 		Manufactured	No			180	Each	0.0000	1.0000			
Placard, Max Load												

B456977 → ① Pld 10.03.29
B56938 → ① Pld 10.03.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Required Date: 3/31/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20600-AD4W5		Purchased	No			180	Each	758.0000	34.0000			
Blind Rivet												

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

ST321

758

110523

212

111477

546

NAS1149DN416J

Purchased

No

180

Each

0.0000

34.0000



Washer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

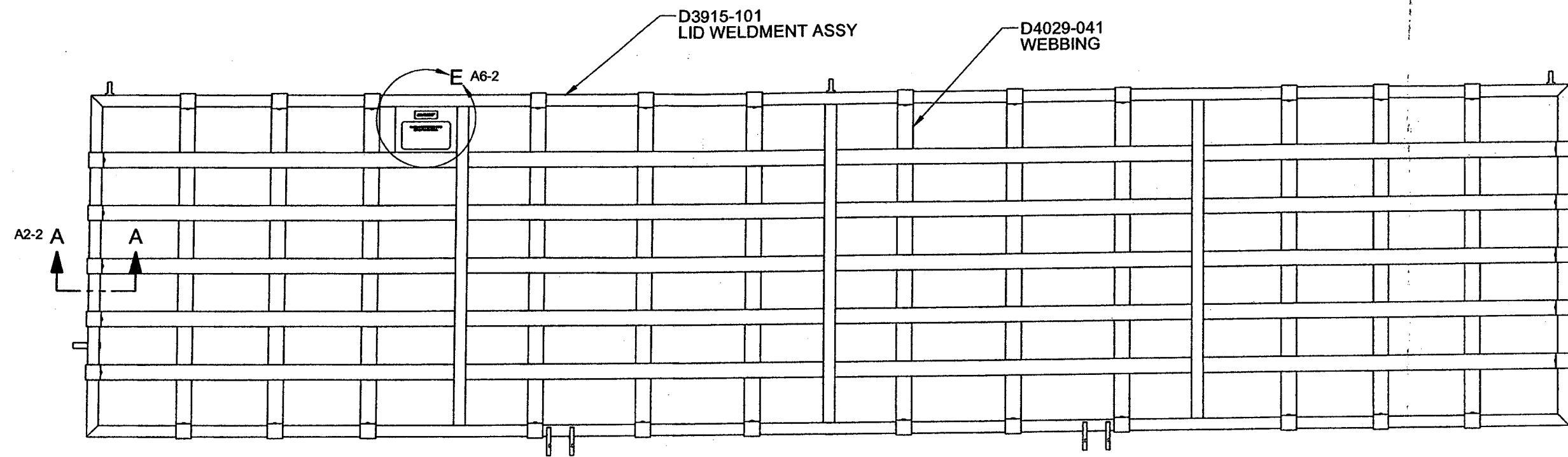
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

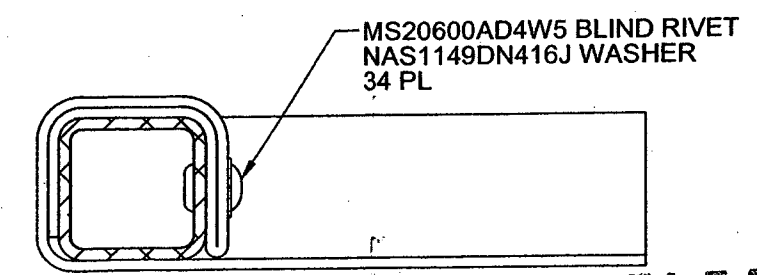
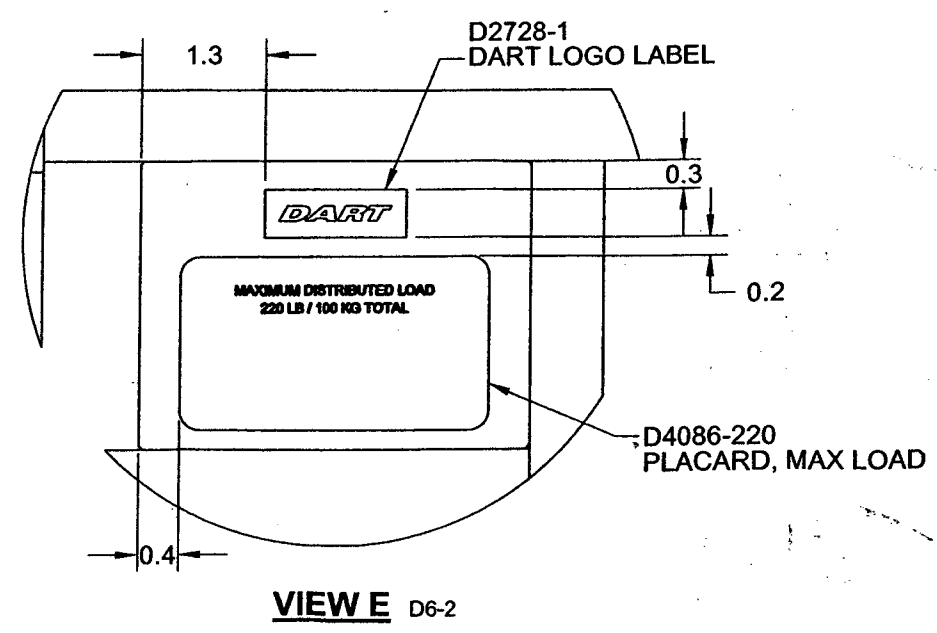
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

110157



D3915-041 LIGHT LID ASSY, LONG BASKET

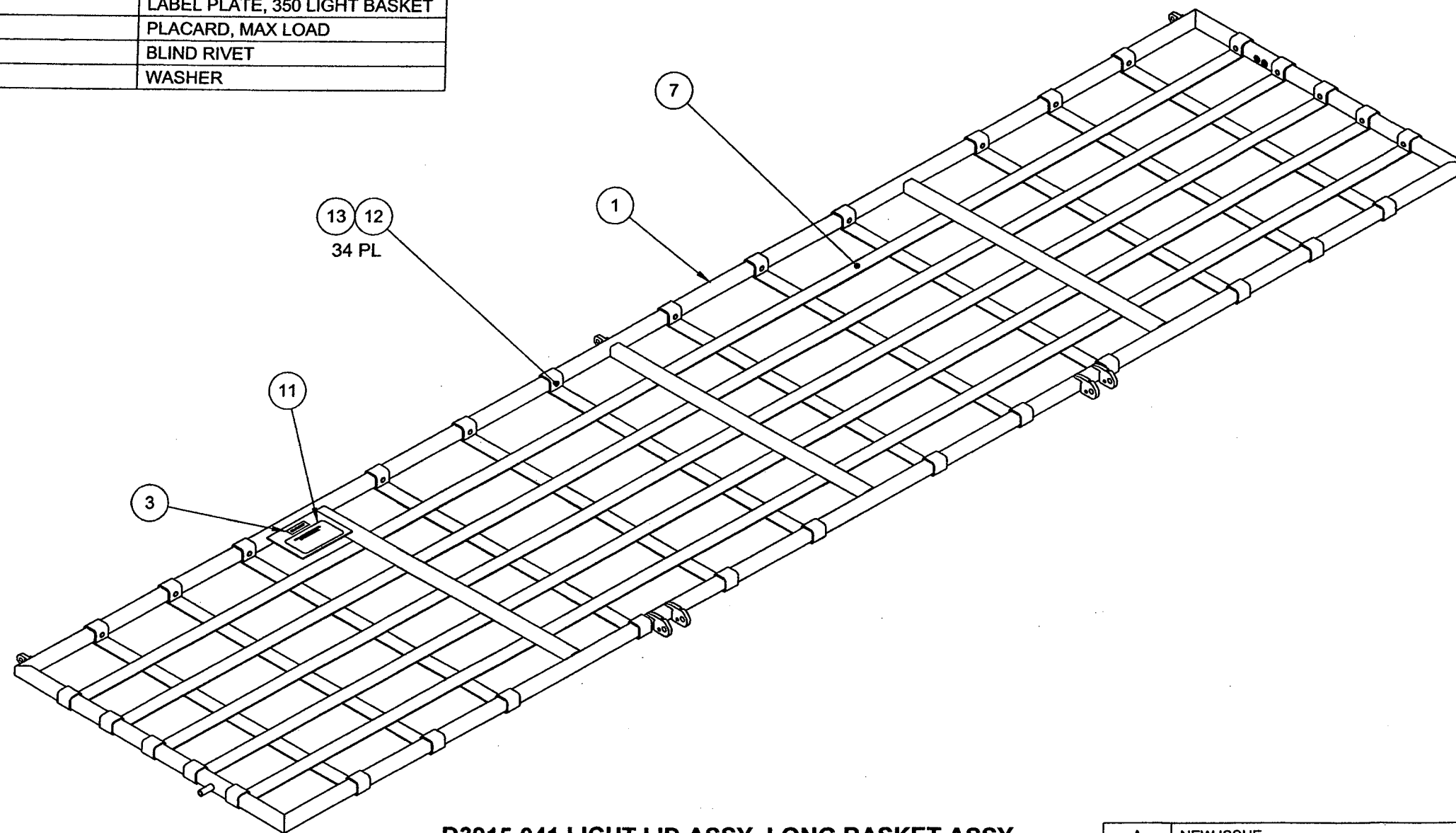


SECTION A-A C8-2

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3915	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID ASSY-LONG BASKET	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ITEM	QTY -041	QTY -101	P/N	DESCRIPTION
	X		D3915-041	LIGHT LID ASSY, LONG BASKET
1	1	X	D3915-101	BASKET LID WELDMENT ASSY
2		2	D3915-1	RIB
3	1		D2728-1	DART LOGO LABEL
4		4	D2957	MOUNTING PLATE
5		3	D4016-5	HINGE HALF
6		3	D4019-3	RIB
7	1		D4029-041	WEBBING (LONG BASKET)
8		1	D4035-045	LID RIB ASSY, FWD
9		1	D4035-047	LID RIB ASSY, AFT
10		1	D4056-1	LABEL PLATE, 350 LIGHT BASKET
11	1		D4086-220	PLACARD, MAX LOAD
12	34		MS20600AD4W5	BLIND RIVET
13	34		NAS1149DN416J	WASHER



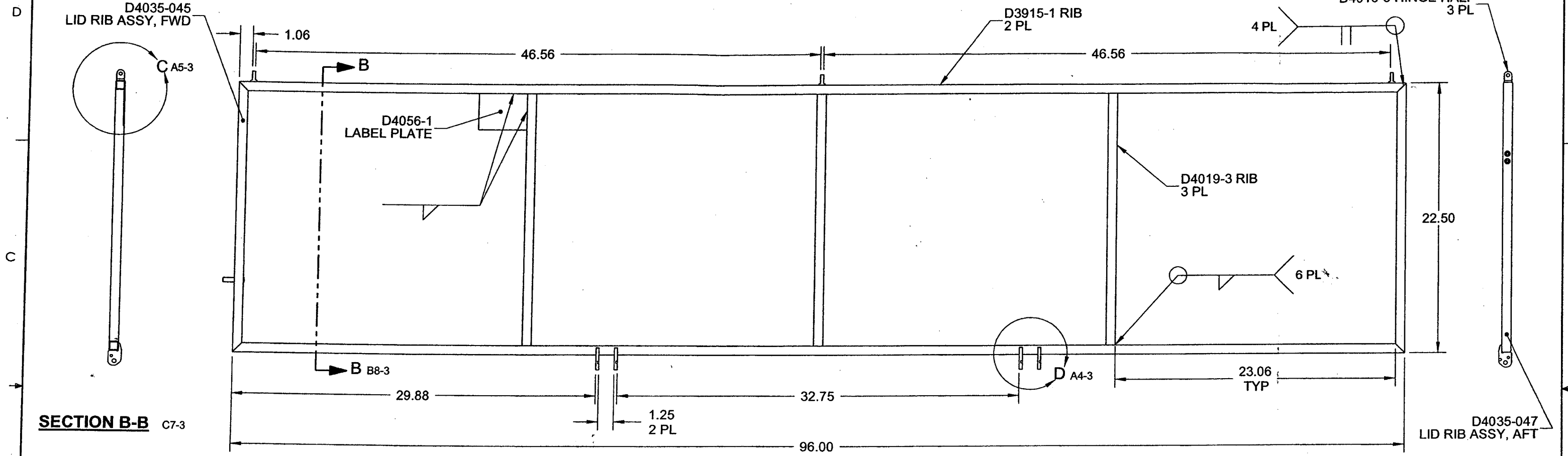
D3915-041 LIGHT LID ASSY, LONG BASKET ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.91 lbs

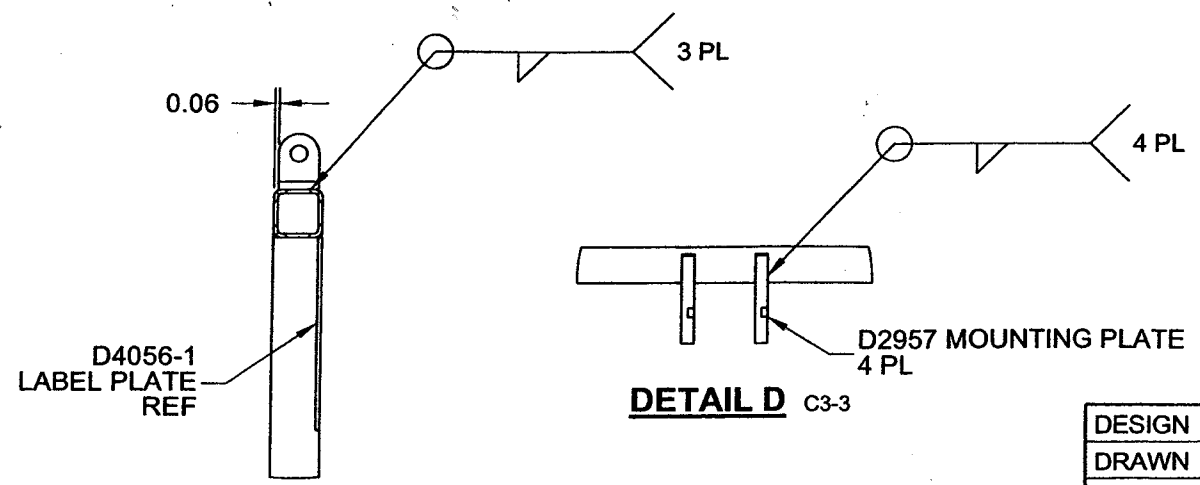
RELEASED
2010-03-22
MD

A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3915	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID ASSY-LONG BASKET	
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SECTION B-B C7-3

D3915-101 BASKET LID WELDMENT ASSY ASSY



DETAIL C D8-3

DETAIL D C3-3

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 4.81 lbs
 - 8) WELD PER DART QSI 004

RELEASED
2010-03-22

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DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3915	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID ASSY-LONG BASKET	NTS
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